

Work Order ID 69926

Tuesday, May 24, 2011 2:22:41 PM



Page 1

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 5/24/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

P

Date: 11-05-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2933

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SL 11-07-14 *(6)*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11-07-14

6 *SL*

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

SL 11-07-14

6 *SL*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, May 24, 2011 2:22:41 PM

Abstract

Accept



Setup Start

Stop

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Stop

**Insp.
Stamp**

0.00

1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

QC

Memo

0.00

Quality Control

140

0.00

[illegible]

HandFinish

Memo

0.00

Hand Finishing

150

0.00

[illegible]

Powdercoat

Memo

0.00

Powder Coating

START TIME:

13:00

OVEN TEMPERATURE:

57.0 ☐ FINISH TIME:

OVEN TEMP 12.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69926

Tuesday, May 24, 2011 2:22:41 PM



Page 3

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 5/24/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 11/07/18

170

Identify as per dwg & Stock Location: 428

0.00



Packaging

Memo

0.00

Packaging

11/7/19

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/19

MF
11-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 2:22:47 PM

Page 1

Work Order ID: 69926

Parent Item: D2933-1

Parent Item Name: Saddle LH In, 206



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC□
IPP Rev:C As per Rev C 07-03-19 JLM □

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	51.0000	1	6			
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Saddle Billet



11-07-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	51	
64777	20	
66965	10	
68170	21	

69677

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 69926	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-1	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.120	.118	.118	.121	.120
B	0.100	0.140		.121	.119	.120	.120	.118
C	0.100	0.140		.115	.112	.112	.113	.113
D	0.210	0.230		.221	.221	.221	.221	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257
L	0.312	0.317		.313	.313	.313	.313	.313
M	0.235	0.240		.237	.238	.238	.238	.238
N	0.100	0.140		.121	.121	.120	.120	.120
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.498	.500	.499	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.490	2.490	2.490	2.490	2.490
S	0.240	0.270		.250	.249	.251	.251	.252
T	0.100	0.180		.140	.140	.140	.140	.140
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.125	1.145		1.138	1.138	1.136	1.135	1.135
Y	1.565	1.585		1.578	1.578	1.576	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: J	Date: 11-07-14
Audited by: MK	Date: 11/07/14
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 69926
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

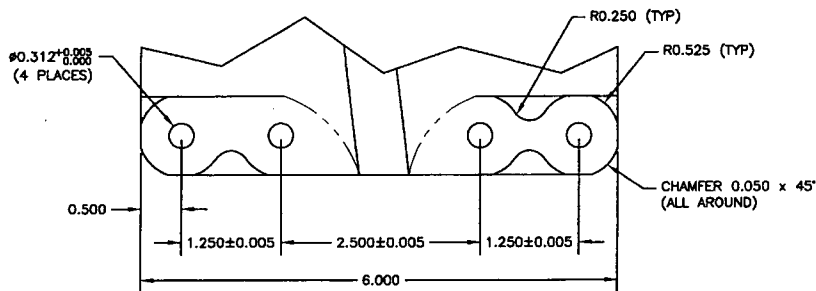
☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.120				
B	0.100	0.140		.120				
C	0.100	0.140		.112				
D	0.210	0.230		.222				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
G	2.495	2.505		2.500				
H	0.510	0.515		.511				
I	1.572	1.582		1.571				
J	2.495	2.505		2.500				
K	0.257	0.262		.257				
L	0.312	0.317		.313				
M	0.235	0.240		.238				
N	0.100	0.140		.120				
O	0.540	0.560		.550				
P	0.490	0.510		.501				
Q	3.715	3.725		3.720				
R	2.470	2.510		2.490				
S	0.240	0.270		.252				
T	0.100	0.180		.140				
U	1.625	1.635		1.630				
V	1.362	1.372		1.367				
W	0.316	0.321		.316				
X	1.125	1.145		1.135				
Y	1.565	1.585		1.575				
Z	0.178	0.198		.188				
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: <i>SL</i>	Date: 11-07-14
Audited by: <i>cmx</i>	Date: 11/07/14
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	<i>[Signature]</i>

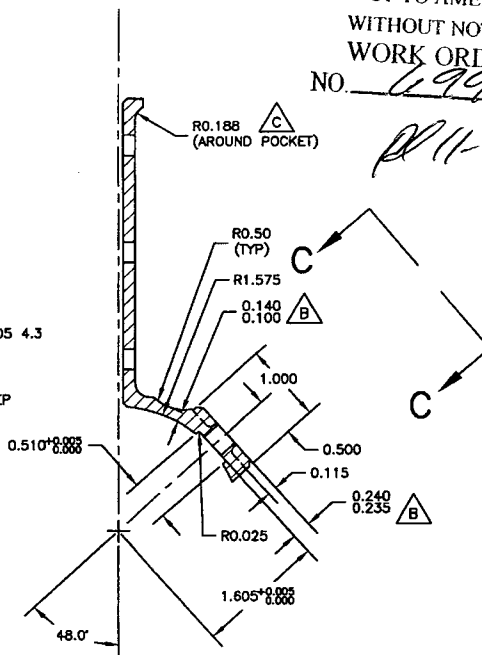


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

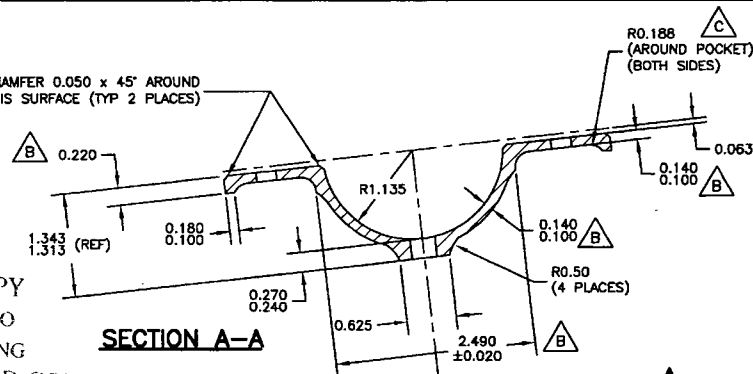
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

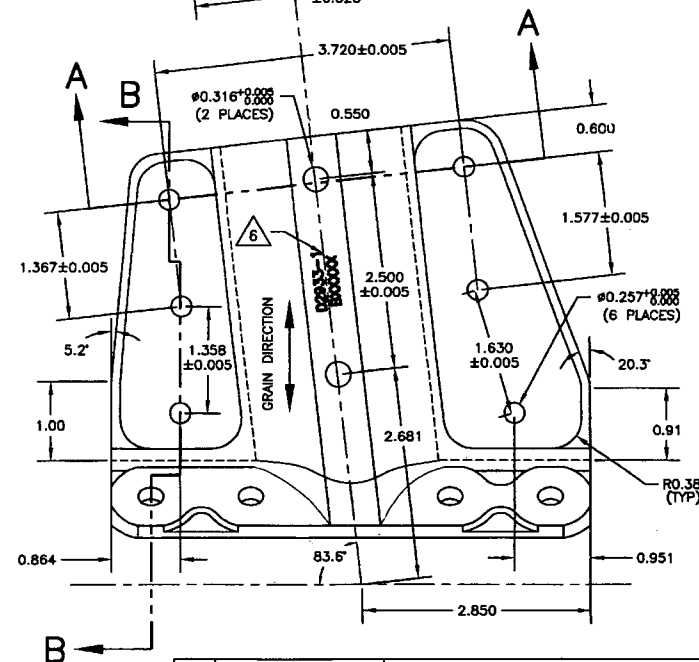


SECTION B-B

CHAMFER 0.050 x 45° AROUND
THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BOLLEAUX, VA

DRAWING NO.
D2933
SHEET 1 OF 1
SCALE
2:3

RELEASED

07-02-12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69924
11-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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